

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025669**Date Inspected:** 19-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

This QA inspector observed ZPMC perform flame cutting and material preparation of miscellaneous splice plates in Bay 14

This QA inspector observed ZPMC performed material preparation grinding on sub-components prior to assembly on Bike path BK3009 assembly

**UT Inspection**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) per ZPMC #09774, Item 1 for OBG Bike Path cantilever box beam BK3004-001-003 assembly/ weld in Bay 6. However, QA observed that the paint removal at the weld was not enough for the required QA UT inspection. The test coverage require a minimum of 10% of the weld to be tested. The weld measured 4700mm and paint removal was approximately 300mm and required minimum length is 470mm. This QA inspector informed ZPMC QC inspector Huang Min of the discrepancy. Huang Min met with Bay 6 Shop Leader in regards with removing more paint. The Shop Leader stated that no one is available to perform paint removal. ZPMC QC inspector Huang Min cancelled the QA UT.

The following digital pictures illustrate paint removal area.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

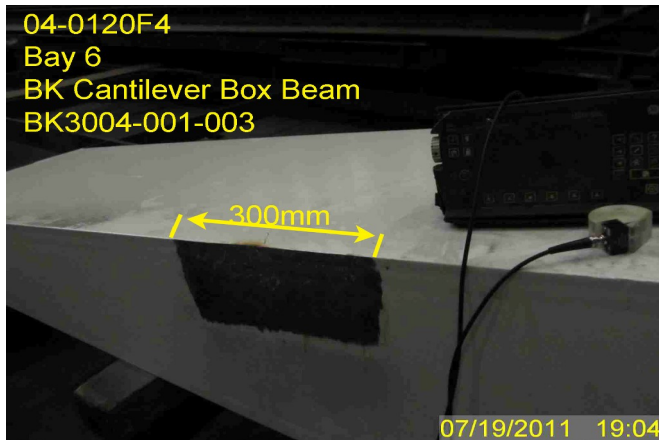
---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

documents.



## Summary of Conversations:

“As noted within the contents of this report.”

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Hasler, Mike
----------------------	--------------

Quality Assurance Inspector
-----------------------------

---

<b>Reviewed By:</b>	Riley, Ken
---------------------	------------

QA Reviewer
-------------